

Date: Tuesday, 5/16/2006 10:39:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters-Services Drawing Name : OH-58 SKIDTUBE ASSEMBLY
 Job Number : 27138A
 Estimate Number : 10475
 P.O. Number : N/A Part Number : D058672041
 This Issue : 5/16/2006 S.O. No. : N/A Drawing Number : D2922 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A1
 Previous Run : 27137A Material : N/A
 Due Date : 6/10/2006 Qty: 1 Um: Each
 Written By : SEE 1st COMMENT BELOW
 Checked & Approved By : 06-05-19
 Comment : Est Rev:C 02.06.28 Re-format; ECN 258 KJ
 Est Rev:D 06.02.06 Added Dt8025 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620

Bent Tube 3" OD

Batch

1326863 Pm' 06-05-19 ①

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Pm' 06-05-19 ①

2-Cut aft end of D2620 bent tube as per dwg D2922

Pm' 06-05-19 ①

3-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia.

Pm' 06-05-19 ①

4-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

Pm' 06-05-19 ①

5-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit

Pm' 06-05-19 ①

7-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922

Pm' 06-05-19 ①

8-Deburr and Blow out all chips form inside the tube

Pm' 06-05-19 ①

9-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R

Aluminum Rod

m18839 / m19101 BE 06-05-19 ①

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 0054.1

Pm 06-05-23 (1)

4.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2923

Web

B27146 Pm 06-05-29 (1)

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

Pm 06-05-24 (1)

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

Pm 06-05-24 (1)

3-Deburr and Blow out all chips from inside the tube

Pm 06-05-24 (1)

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R

Sikaflex-291

M100901

Pm 06-05-29 (1)

Sikaflex expire date: *06-11-01*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-5-29

7.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14400 BE 06-05-19 (1)

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Job Number: 27138A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

B25864 BE 06-05-30 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

m 18839 BE 06-05-30 (1)

3-Grind welds flush as per Dwg D2922

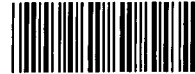
4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

DP06-6-1

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 06-06-05
06-06-06 (1)*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-07-11 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 07 11 (1)

13.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

25909

FC 06 07 11 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 27138A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-15 Wearshoe

624845

FC

15.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-21 Wearshoe

620917

FC

16.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2924 Wearshoe

22598

FC

17.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 MS27039-1-08 Screw

191551

FC

18.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 AN960JD10L Washer

101294

FC 06 07 11 ①

W/O:		WORK ORDER CHANGES					
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Job Number: 27138A

Part Number: D058672041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032130	Insert
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
50	ALS4-1032-130	Insert	M18293 <i>M19393</i>
or (see QSI 017)			

FC

20.0	D26511	Plug
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-1	Plugs	<i>B25365</i>

FC

21.0	D26513	O-Ring
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-3	O-Rings	1024013 <i>25866</i>

FC

22.0	D2646	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	<i>25381</i>

FC

23.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-08	Screw	<i>19551</i>

FC 06 07 11 ①

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/04

NOTE: Date & initial all entries

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Job Number: 27138A

Part Number: D058672041

Job Number:

Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10L

Washer

Comment: Qty.: 2.0000 Each(s) Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer 101291

FC

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 11 06

101193

FC

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

FC

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 11 06

101193

FC

06 07 11

①

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

m 10/26/06

Batch:

A-M 06-07-11

①

26.0

QC3/5

INSPECT WORK/WING WALK

Comment: INSPECT WORK/WING WALK

DL 06/07/12

①

27.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A

PU

28.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.18

Job Completion

u 06.07.17

W/O:		WORK ORDER CHANGES					
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DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	# CP 01.08.20	Ø0.640 WAS Ø0.625	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

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WORK ORDER

